

# Work Order ID 77441

December-07-11 11:03:56 AM

**\*77441\***

Page 1

Item ID: D3507-1-BENT

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube Assembly EC135

Start Date: 07/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/07

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3507	Rev C								

120

0.00

**\*120\***

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1- Bend tube as per program D3507 on CNC Bender FOLIO 6 and Dwg D3507,  
use DT9632 bending aide  
2- Cut FWD END of tube as per dwg D3507

PK 12/02/22

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

DP 12-2-22 PTO

300

Identify as per dwg & Stock Location: LG

0.00

**\*300\***

Packaging

Packaging

Memo

0.00

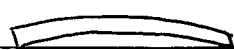


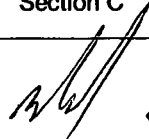


Packaging

PK 12/02/22

(2)

W/O:		77441 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2962-150 PAR #: \_\_\_\_\_ Fault Category: Supplier NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/07	100	Qty +1 length of extrusion D2962-150 has a Bend through out the tube. ie → 	 AS7042 11/12/07	Scrap length + Replate.	 12-2-22	 12/02/23	 AS7042 11/12/07	 11/12/07
		shaped like a banana. R.C.						

NOTE: Date & initial all entries

**Work Order ID 77441****\*77441\***

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Item ID: D3507-1-BENT

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube Assembly EC135

Start Date: 07/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

310

QC21- Final Inspection - Work Order Release

0.00


**\*310\***

QC

Memo

0.00

Quality Control

 M.C.J. 12/02/2312-02-23  
G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 77441

**\*77441\***

Parent Item: D3507-1-BENT

**\*D3507-1-BENT\***

Parent Item Name: Skidtube Assembly EC135

Start Date: 07/12/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.09.17 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2962-150		Manufactured	No			100	Each	54.0000	1	1			
<b>*D2962-150*</b>									<b>**</b>				
3.540 Outer Tube, Extrud													

Location

HALL

Loc Qty

54

Loc Code

59934

54

①

**DD 11-12-7**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

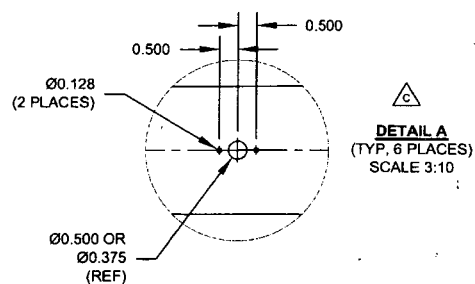
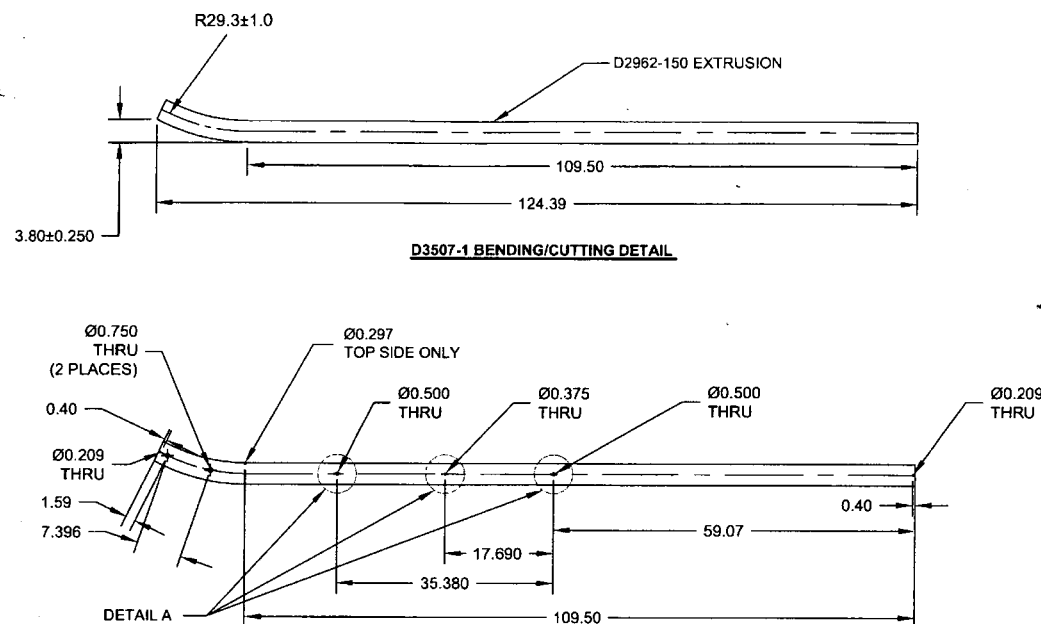
#### GENERAL NOTES:

- FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- USE DART DRILL TEMPLATE DT8888 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE

DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA
DRAWN	JTC	
CHECKED	PH	
MFG. APPR.	PH	
APPROVED	PH	
DE APPR.	PH	
DATE	07.09.19	

DRAWING NO.	D3507	REV. C
TITLE	EC 135 SKIDTUBE	SCALE
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 WORK CENTER  
 NO. 77441

M.C.S  
 11/12/07

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

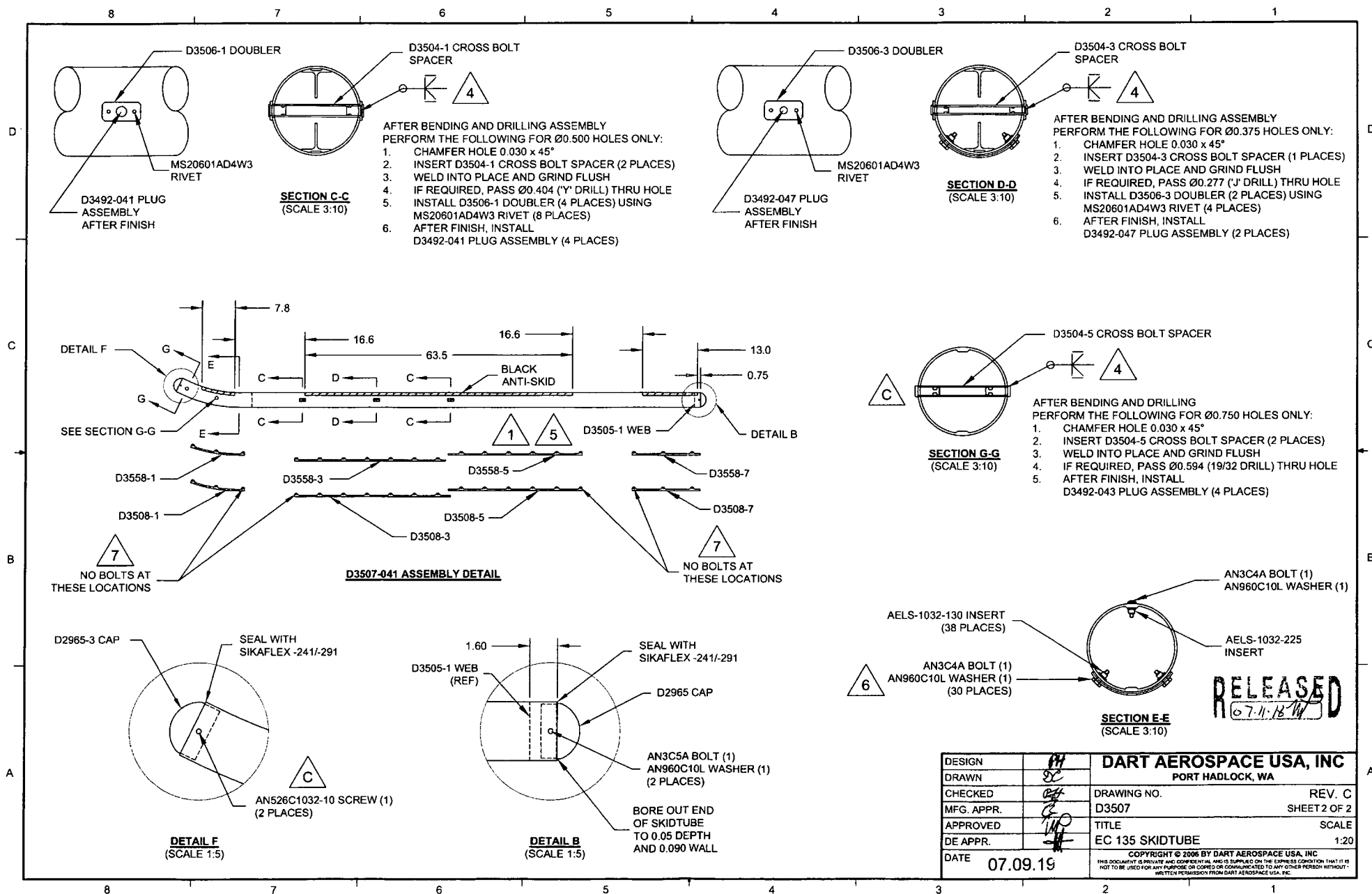
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**NOTE:** Date & initial all entries



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